

ASAP
Push

Work Order ID 109303

November-18-13 3:15:30 PM

109303

Page 1

Item ID: D3531-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 11/18/13 Start Qty: 8.00 *8*

Cust Item ID:

Required Date: 11/19/13 Req'd Qty: 8.00 *8*

Customer:

Reference:

Approvals: Process Plan: [Signature] Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3531	B								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3531								
6061.040	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

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Item ID: D3531-1

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Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 11/18/13 Start Qty: 8.00

8

Cust Item ID:

Required Date: 11/19/13 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				9			
125 *125* Small Fab Small Fab	QC8- Inspect parts - second check Memo DIMPLES HOLES AS PER DWG	0.00 0.00				9x			13/11/20
130 *130* Brake NC Brake NC	Bend as per dwg NC BRAKE Memo	0.00 0.00				9			13/11/20

DAS
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9-89

DAS
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Item ID: D3531-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 11/18/13 Start Qty: 8.00

8

Cust Item ID:

Required Date: 11/19/13 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 DAS 27 0.00 9-89 13/11/20				9			
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00				9	13/11/20		
160 *160* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				9x		13/11/21	DAS 36 9-

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Item ID: D3531-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 11/18/13 Start Qty: 8.00 *8*

Cust Item ID:

Required Date: 11/19/13 Req'd Qty: 8.00 *8*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>C-A</u>	0.00				<u>9x</u>			<u>13/11/21</u>
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

13-11-21

DAS
36
9-89

Picklist Print

November-18-13 3:15:29 PM

Page 1

Work Order ID: 109303

Parent Item: D3531-1

Parent Item Name: Bracket

Start Date: 11/18/13

Required Date: 11/19/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified by DD
REV.B DD VERF:JLM

IPP REV:B 12.10.24 PER DWG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No			100	sf	401.2910	0.3783	④			

Jm 13-11-20

Location

Loc Qty

Loc Code

MAT021

401.291

m126350

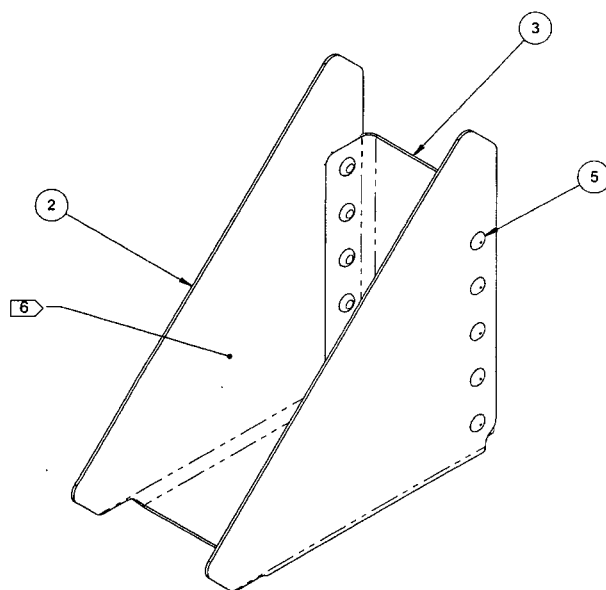
209.291

m126981

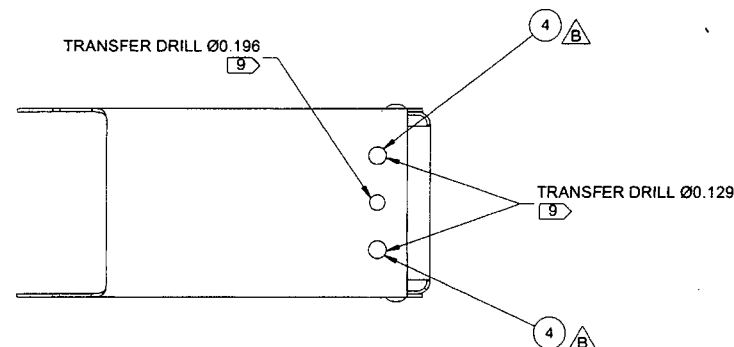
192

126981

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3531-041	BRACKET ASSEMBLY
2	1	D3531-1	BRACKET
3	1	D3531-3	BRACKET FRONT PLATE
4	2	MS20426AD4-4	RIVET
5	10	MS20470AD4-4	RIVET



D3531-041 BRACKET ASSEMBLY



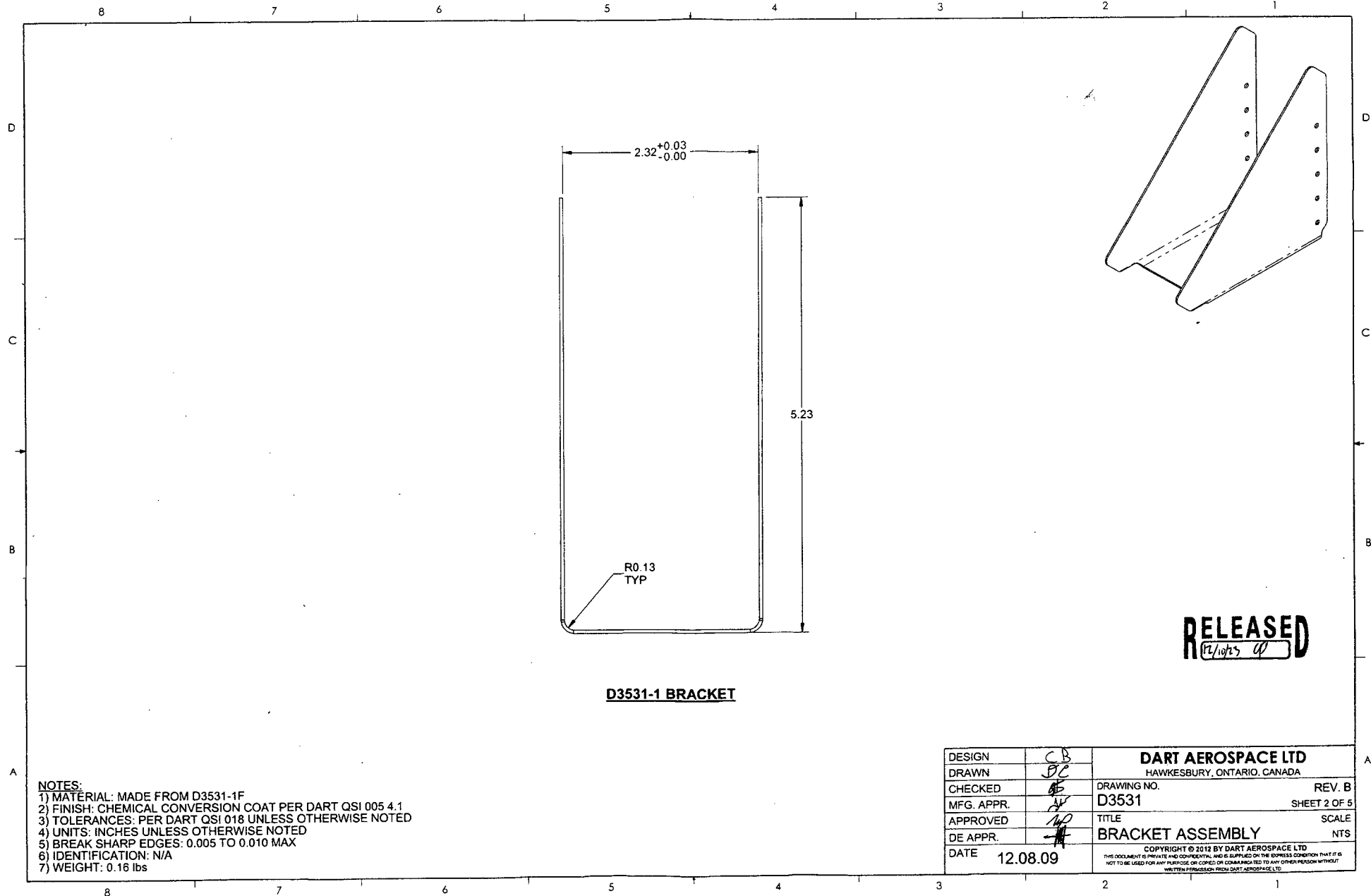
**D3531-041 BRACKET ASSEMBLY
BOTTOM VIEW**

RELEASED
12/10/13 9
PER EN 12-669

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON INSIDE OF BRACKET ASSEMBLY, WHERE INDICATED
- 7) WEIGHT: 0.22 lbs
- 8) ASSEMBLE PER DART QSI 003
- 9) TRANSFER DRILL HOLES FROM D3531-1 BRACKET THROUGH D3531-3 BRACKET FRONT PLATE BEFORE FINISHING

B	CHANGE BOTTOM RIVETS FROM MS20470AD4-4 TO MS20426AD4-4, ZN C2-1, C5-3. ADD CSK, ZN C5-3. CORRECT BEND LINE DIM, ZN C4-3. UPDATE TO CURRENT DWG STANDARDS, REF PAR 10-47.	DC	12.08.09
A	NEW ISSUE	CB	07.06.19
REV	DESCRIPTION	BY	DATE
DESIGN	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DC	D3531	SHEET 1 OF 5
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	BRACKET ASSEMBLY	NTS
DATE	12.08.09	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

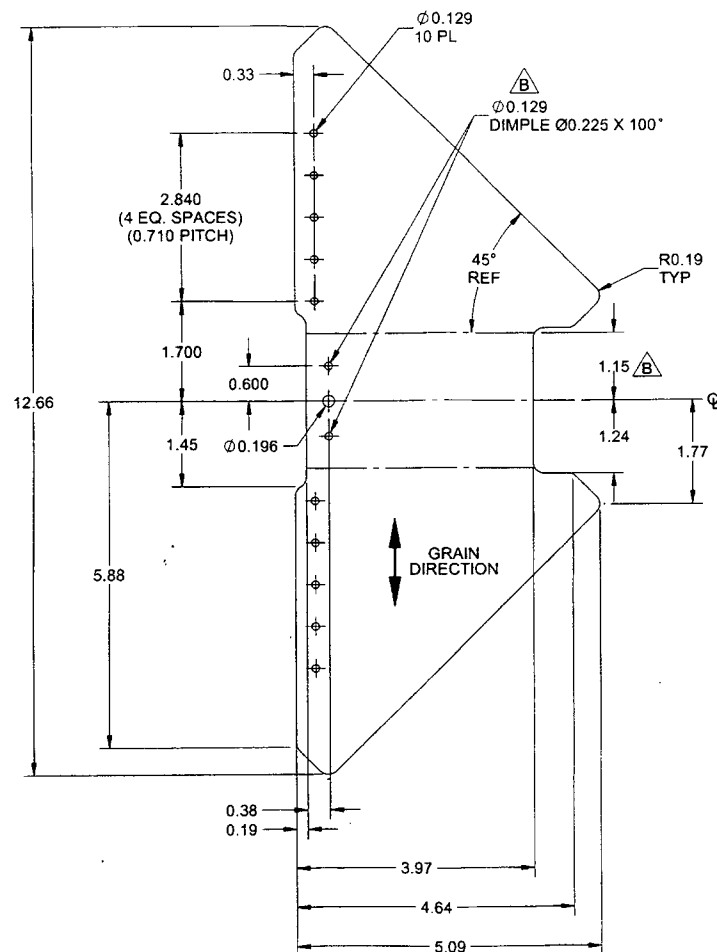


D3531-1 BRACKET

RELEASED
12/10/15

- NOTES:**
- 1) MATERIAL: MADE FROM D3531-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.16 lbs

DESIGN	CB	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SE	DRAWING NO.	REV. B
MFG. APPR.	AV	D3531	SHEET 2 OF 5
APPROVED	MD	TITLE	SCALE
DE APPR.	TH	BRACKET ASSEMBLY	NTS
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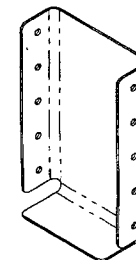
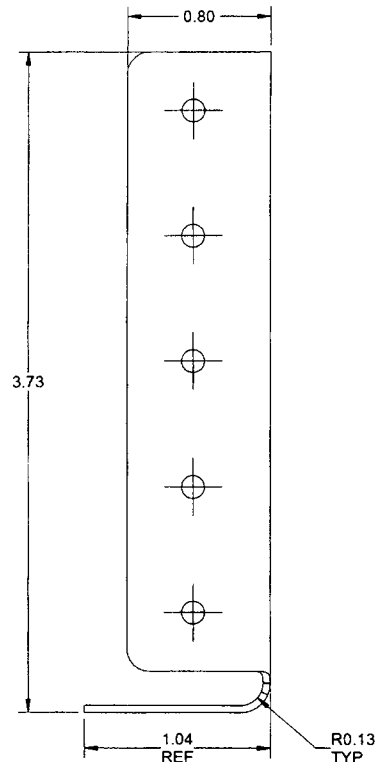
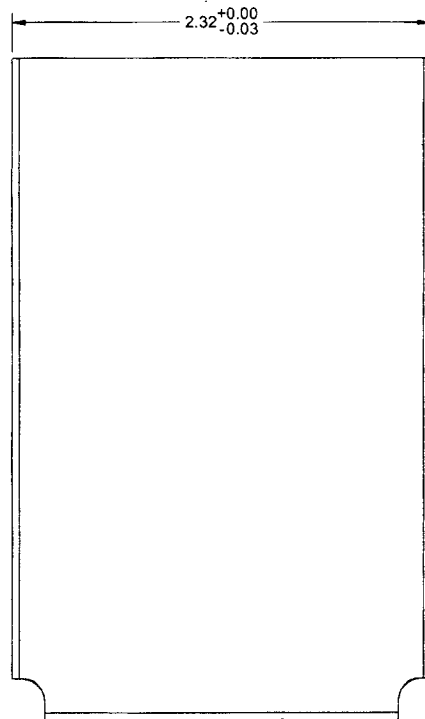
D3531-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.16 lbs

RELEASED
12/14/23

DESIGN	CB	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	AP	D3531	SHEET 3 OF 5
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	BRACKET ASSEMBLY	
DATE	12.08.09	NTS	
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RELEASED
12/10/13 Q

D3531-3 BRACKET FRONT PLATE

NOTES:

- 1) MATERIAL: MADE FROM D3531-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs

DESIGN	CB	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	JS	D3531	SHEET 4 OF 5
APPROVED	MD	TITLE	SCALE
DE APPR.	TH	BRACKET ASSEMBLY	NTS
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DART AEROSPACE LTD		Work Order:	109303
Description: Bracket		Part Number:	D3531-1
Inspection Dwg: D3531	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.196	+0.005/-0.001	0.197"	-		U	Jamo
Ø0.129	+0.005/-0.001	0.129"	-		U	
0.33	+/-0.030	0.338"	-			
2.840	+/-0.010	2.847"	-			
1.70	+/-0.030	1.701"	-			
1.45	+/-0.030	1.45"	-			
0.38	+/-0.030	0.38"	-			
0.19	+/-0.030	0.19"	-			
5.88	+/-0.030	5.88"	-			
12.66	+/-0.030	12.66"	-			
0.600	+/-0.010	0.604"	-			
1.77	+/-0.030	1.77"	-			
1.24	+/-0.030	1.24"	-			
1.16	+/-0.030	1.16"	-			

Measured by:	Jm	Audited by:	ShB	Preliminary Approval:	
Date:	13-11-19	Date:	13/11/20	Date:	

Rev	Date	Change	Revised by	Approved
A	07.10.15	New Issue	KJ/EC/DD	
B	13.02.27	Dwg Rev updated	KJ	